

Work Order ID 88417

August-01-12 1:28:07 PM

Sup Aug 10

88417

Page 1

Item ID: D350-607-545

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Utility-Basket

Start Date: 7/27/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *[Signature]*

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D350-607-3

A

100

100

DOCUMENT CONTROL *sp*

0.00

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-545 CHG004

DAS 16 9-83 12/8/10

110

110

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ****

12/8/17 sp

115

115

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Inspect label on lid

DAS 16 9-83 12/8/10

(Signature)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

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Page 1

Work Order ID: 88417

Parent Item: D350-607-545

Parent Item Name: Heli-Utility-Basket

Start Date: 7/27/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-06-28 JLM VERIFIED BY: LL IPP REV:B 10-08-19 AS PER
REV.A DD VERF BY:EC IPP Rev:C 11.02.09 add to install label DD verf
by:EC IPP REV:D 12.03.06 AS PER ECN12-535 DD VERF:EC IPP REV:E
12.07.24 AS PER ECN 12-610 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
5 D350-607-511 CH702 Quick Release Basket Mounting Installation		Manufactured	No			110	Each	3.0000	0	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		1							
				85744		1							
				PK12		2							
				85347		2							
5 D2690-6 Lanyard Assembly		Manufactured	No			110	Each	29.0000	0	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST017		29							
				86926		29							
5 D3912-041 Eyebolt Receiver Assembly		Manufactured	No			110	Each	2.0000	0	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				st507		2							
				86564		2							
6 D4032-041 Short Basket Assembly (350)		Manufactured	No			110	Each	0.0000	0	1			
6 D4085-3 Placard, Instructions		Manufactured	No			110	Each	13.0000	0	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST092		13							
				87037		13							

88622

12/8/12

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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Page 2

Work Order ID: 88417

Parent Item: D350-607-545

Parent Item Name: Heli-Utility-Basket

Start Date: 7/27/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

D4086-220
Placard, Max Load

Manufactured No

110 Each 30.0000

0 1

Location

Loc Qty

Loc Code

ST093

30

69500

2

84149

16

85618

12

Manufactured No

110 Each 8.0000

0 1

Location

Loc Qty

Loc Code

GA

-4

ST103

12

85792

8

Manufactured No

110 Each 12.0000

0 1

Location

Loc Qty

Loc Code

ST103

12

85795

12

Manufactured No

110 Each 1.0000

0 1

Location

Loc Qty

Loc Code

GA

1

85791

1

D4151-043
Basket Fwd Hardpoint Assembly, Upper

D4150-041
Attachment Arm Assembly

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Shop Packet Print

Page 2

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Work Order ID: 88417

Parent Item: D350-607-545

Parent Item Name: Heli-Utility-Basket

Start Date: 7/27/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

AN413A Purchased No 110 Each 1,237.0000 6 6 sf

Bolt

Location	Loc Qty	Loc Code
ST356	500	
122416	500	
ST357	737	
120187	19	
120422	2	
120770	12	
121652	588	
122063	116	

AN4G15 Purchased No 110 Each 35.0000 1 1 sf

BOLT

Location	Loc Qty	Loc Code
ST358	35	
120124	1	
121146	34	

AN310C4 Purchased No 110 Each 45.0000 1 1 sf

Nut

Location	Loc Qty	Loc Code
ST344	45	
120360	1	
121166	3	
121444	21	
122151	20	

MS17984-G413 Purchased No 110 Each 28.0000 1 1 12/8/17 sf

PIN, QUICK RELEASE

Location	Loc Qty	Loc Code
331	25	
122452	25	
ST315	3	
114340	1	
118612	2	

NCR: Yes / No

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Page 4

Work Order ID: 88417

Parent Item: D350-607-545

Parent Item Name: Heli-Utility-Basket

Start Date: 7/27/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

5,865.0000

6

6

Nut

Location

Loc Qty

Loc Code

314

5000

122452

5000

ST300

865

104248

1

116823

8

119075

116

121011

193

121444

547

MS24665-151

Purchased

No

110

Each

144.0000

0

1

Gutter Pin

Location

Loc Qty

Loc Code

ST309

144

17566

144

NAS1515H4L

Purchased

No

110

Each

387.0000

2

2

WASHER

Location

Loc Qty

Loc Code

FG

8

103691

8

ST277

379

118709

8

120390

371

NAS1149F0432P

Purchased

No

110

Each

1,490.0000

12

12

Washer

Location

Loc Qty

Loc Code

275

600

122441

600

ST275

890

121350

15

122151

875

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Shop Packet Print

Page 4

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Page 5

Work Order ID: 88417

Parent Item: D350-607-545

Start Date: 7/27/12

Required Date: 8/10/12

Parent Item Name: Heli-Utility-Basket

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0463R

Purchased

No

110

Each

722.0000

3

3

Washer

12/8/12

Location

Loc Qty

Loc Code

FP001

1

115358

1

ST297

721

117735

17

119097

704

3

August-01-12 1:28:06 PM

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Page 5

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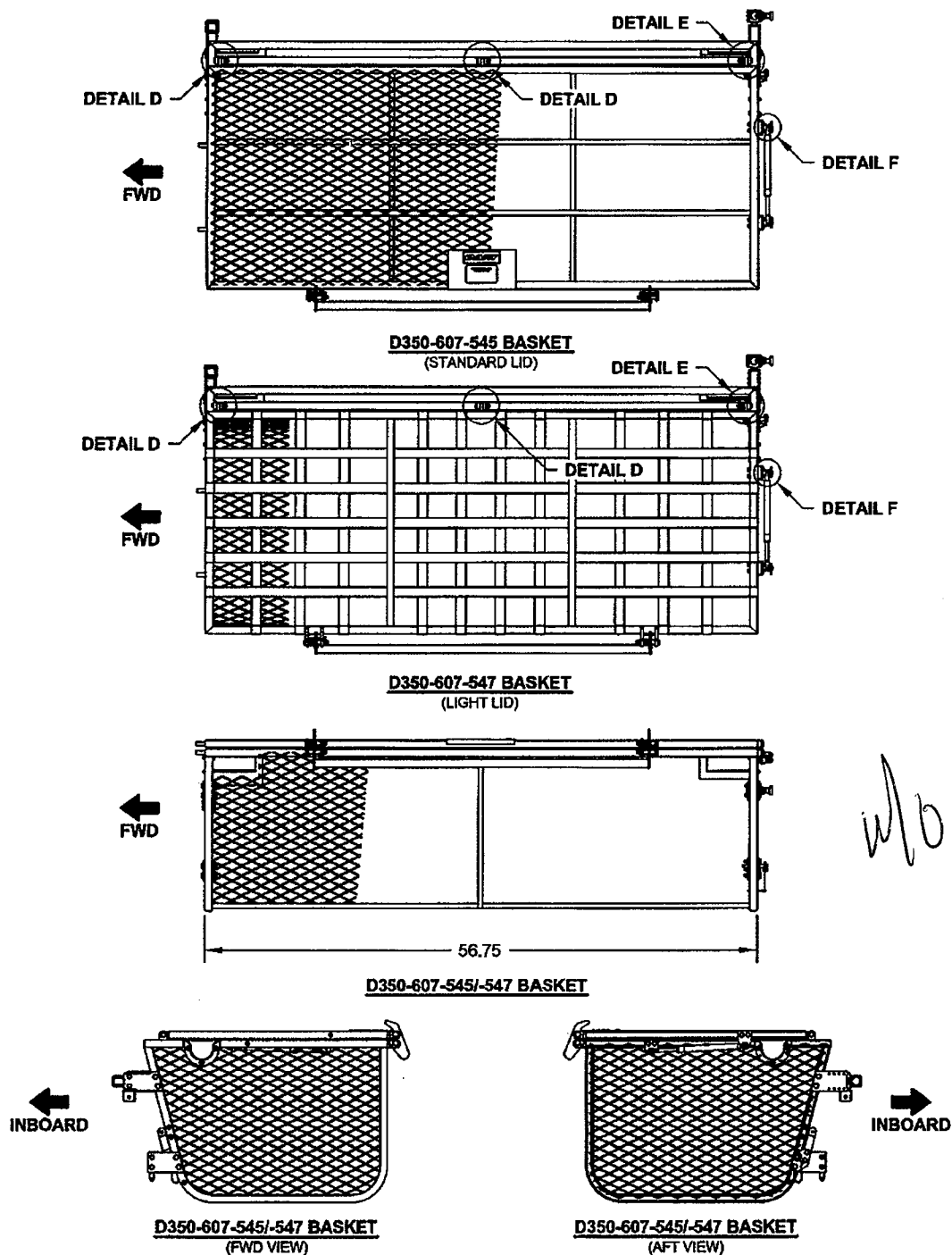


FIGURE 3: D350-607-545/-547 BASKETS
LH INSTALLATION SHOWN, RH OPPOSITE

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Revision: **A**
Date: 10.06.28

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Operator <input type="checkbox"/> Material <input type="checkbox"/> Setup <input type="checkbox"/> Other <input type="checkbox"/> Process <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

3.6.2 OPTION 2

- 3.6.2.1 Open lid for ease of removal of D3969-3 Gas Spring while fully extended.
- 3.6.2.2 Remove and retain the D3953-17 Gas Spring Spacer and D3953-19 Gas Spring Bracket mounting the Gas Spring to the lid by unfastening qty (2) each AN3-14A Bolts, MS21042L3 Nuts and qty (4) NAS1149F0332P Washers. Refer to Section View G-G, Figure 7a.
- 3.6.2.3 Remove and retain the D3953-17 Gas Spring Spacer and D3953-21 Gas Spring Bracket mounting the Gas Spring to the basket's base by unfastening qty (2) each AN3-14A Bolts, MS21042L3 Nuts and qty (4) NAS1149F0332P Washers. Refer to Section View F-F, Figure 7a.
- 3.6.2.4 Touch up finish as required per Item 5.2.10 of ICA-D350-607.
- 3.6.2.5 At the opposite end of the basket, install the D350-607-421 Prop Arm Kit per Figure 7b.
Torque all nuts to 50-70 in-lbs (5.7-7.9 N-m).

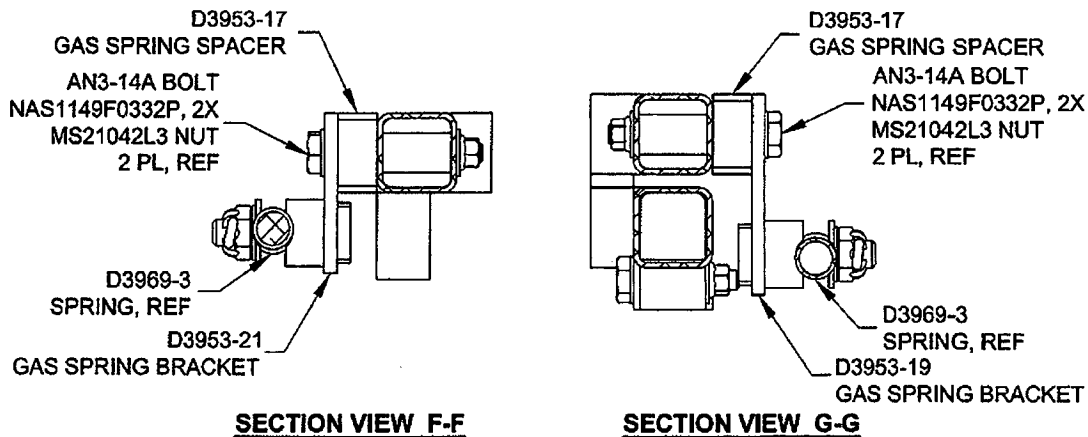


FIGURE 7a: GAS SPRING DETAILS
SECTION VIEWS FROM FIGURE 7b

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
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FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-607-541 (Standard Basket)	80.7 lb 36.6 kg	± 49.1 in ± 1.25 m	± 3962 in-lb ± 45.8 m-kG	135 in 3.43 m	10895 in-lb 125.5 m-kG
D350-607-543 (Lightweight Basket)	65.7 lb 29.8 kg	± 49.1 in ± 1.25 m	± 3226 in-lb ± 37.3 m-kG	135 in 3.43 m	8870 in-lb 102.2 m-kG
D350-607-545 (Standard Basket)	58.7 lb 26.2 kg	± 49.1 in ± 1.25m	± 2882 in-lb ± 32.8 m-kG	135 in 3.43 m	7925 in-lb 89.9 m-kG
D350-607-547 (Lightweight Basket)	47.7 lb 21.6 kg	± 49.1 in ± 1.25 m	± 2342 in-lb ± 27.0 m-kG	135 in 3.43 m	6440 in-lb 74.1 m-kG
D350-607-511 (Quick Release Basket Mounting Kit)	7.2 lb 3.3 kg	± 36.9 in ± 0.94 m	± 266 in-lb ± 3.1 m-kG	135 in 3.43 m	972 in-lb 11.3 m-kG

5.0 PARTS LIST

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET
	X					D350-607-543	HELI-UTILITY-BASKET
		X				D350-607-545	HELI-UTILITY-BASKET
			X			D350-607-547	HELI-UTILITY-BASKET
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT
					X	D350-607-501	CONVERSION KIT
1	1	1	1		1	D2690-6	LANYARD
				4	4	D3910-3	X-TUBE LUG
1	1	1	1		1	D3912-041	EYEBOLT RECEIVER ASSY
				8	8	D3984-030	RUBBER EXTRUSION, X-TUBE
1						D4030-041	LONG BASKET ASSY
	1					D4030-043	LONG BASKET ASSY, LIGHTWEIGHT
		1				D4032-041	SHORT BASKET ASSY
			1			D4032-043	SHORT BASKET ASSY, LIGHTWEIGHT
1	1	1	1		1	D4085-3	PLACARD-INSTRUCTIONS
1					1	D4086-200	PLACARD, MAX LOAD
	1				1	D4086-215	PLACARD, MAX LOAD
		1			1	D4086-220	PLACARD, MAX LOAD
			1		1	D4086-232	PLACARD, MAX LOAD
				1	1	D4148-041	FWD X-TUBE LUG ASSY
				1	1	D4149-041	AFT X-TUBE LUG ASSY
1	1	1	1		1	D4150-041	ATTACHMENT ARM ASSY
1	1	1	1		1	D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
1	1	1	1		1	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
6	6	6	6		6	AN4-13A	BOLT
				16	16	AN4-14A	BOLT
1	1	1	1		1	AN4C15	BOLT
1	1	1	1		1	AN310C4	CASTELLATED NUT
1	1	1	1		1	MS17984-C413	QUICK RELEASE PIN
6	6	6	6	16	22	MS21042L4	NUT (OR MS21042-4)
1	1	1	1		1	MS24665-151	COTTER PIN
2	2	2	2		2	NAS1515H4L	WASHER
12	12	12	12	32	44	NAS1149F0432P	WASHER
3	3	3	3		3	NAS1149C0463R	WASHER

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